

Date: Friday, 08/02/2008 9:12:39 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 37302
 Estimate Number : 13167
 P.O. Number :
 This Issue : 08/02/2008 S.O. No. : *R&D*
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A new issue 08-02-08 DD verified by:ec

Drawing Name : INSTRUMENT PANEL *Rev 08.06.03.*
 Part Number : D3705-043 *08.05.03*
 Drawing Number : D3705 *MR*
 Project Number : N/A
 Drawing Revision : *MR Prototype*
 Material :
 Due Date : 15/02/2008 Qty: 1 Um: Each
Positive Read

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>NA</i>
2.0	D37051	MAIN PANEL <i>MAIN PANEL</i> <i>batch B37293</i> <i>PD 08-02-08 ①</i>
3.0	D37053	COVER PLATE <i>COVER PLATE</i> <i>batch B37294</i> <i>PD 08-02-08 ①</i>
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 <i>Alum Rod Batch: M106330</i> <i>1-Assemble as per dwg D3705 and weld as per QSI004</i> <i>*****nice weld all around and buff weld smooth****</i> <i>PD 08-06-05</i>
5.0	QC9	VISUAL WELDING INSPECTION <i>Comment: VISUAL WELDING INSPECTION</i> <i>08/06/05 ①</i>
3.1	D3706-1	Lock Bracket <i>Qty: 1</i> <i>Batch: B05023</i> <i>3.2 D3706-3 Guide <i>Qty: 1</i> <i>Batch: B05022</i></i> <i>08/06/04</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL

Job Number: 37302

Part Number: D3705041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL

18/06/05

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

18/02/20

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat ~~White~~ Black (Ref: 4.3.5.1) as per QSI 005 4.3

18/05/20

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18/06/05

10.0 PACKAGING 1

PACKAGING RESOURCE #1



DAN STOW

18/02/20

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: _____

11.0 QC21

FINAL INSPECTION/W/O RELEASE



18/06/05 Prototype
18/05/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-16

POSITIVE RECALL
EFFECTIVE ~~06/02/08~~ AUTH ~~LM~~
RELEASED ~~06/02/08~~ DATE ~~18/05/20~~

W/O RE-REVISED
TO ACCOMMODATE
LATEST REV. 18/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

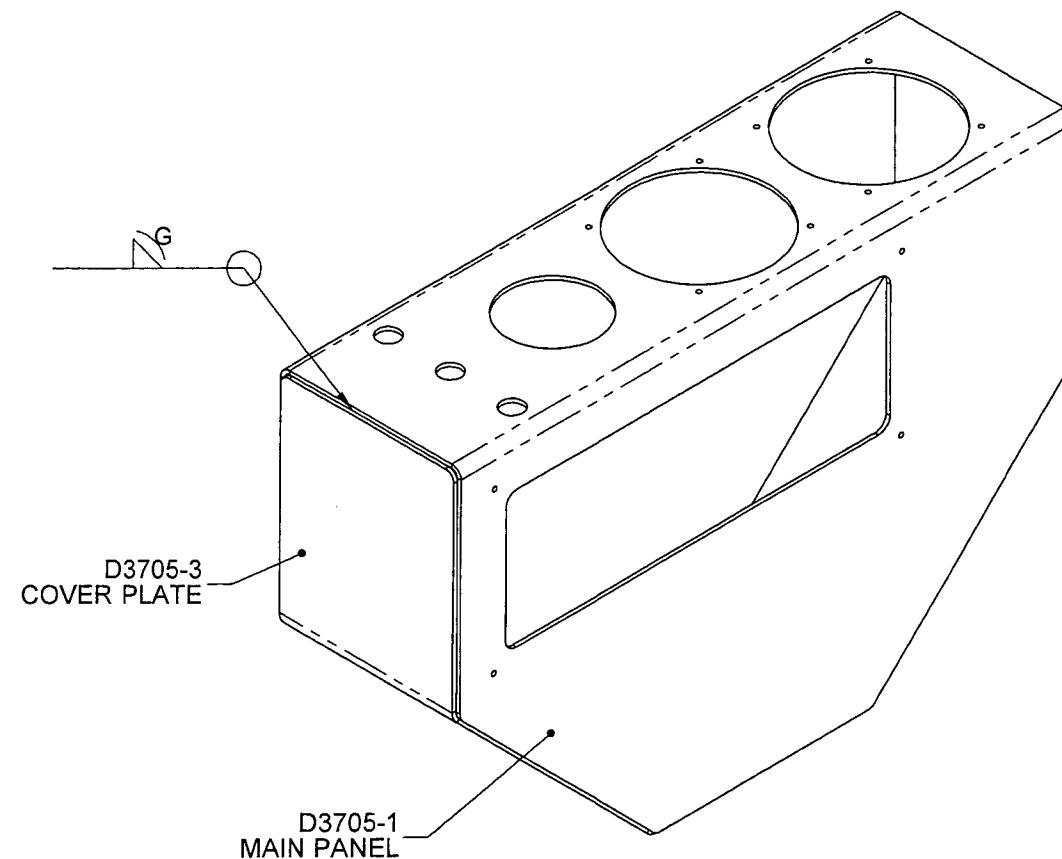
Date: 08.02.07

Product Name: VERTICAL REFERENCE DOOR

Requested By: MB

Design Manager Approval: _____

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3705-1F	MIAN PANEL	08.02.06	YES	ASAP	SEE BELOW	
1	D3705-3F	COVER PLATE	08.02.06	YES	ASAP	SEE BELOW	
1	D3705-041	INSTRUMENT PANEL	08.02.06	—	as	as	
						GIVE ALL W/Os AND PARTS TO D. STOW	



D3705-041 INSTRUMENT PANEL

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.45 lbs
- 8) WELDING: PER DART QSI 004

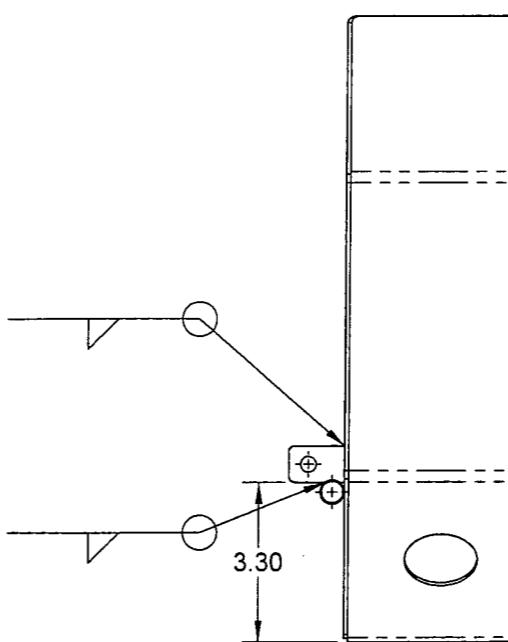
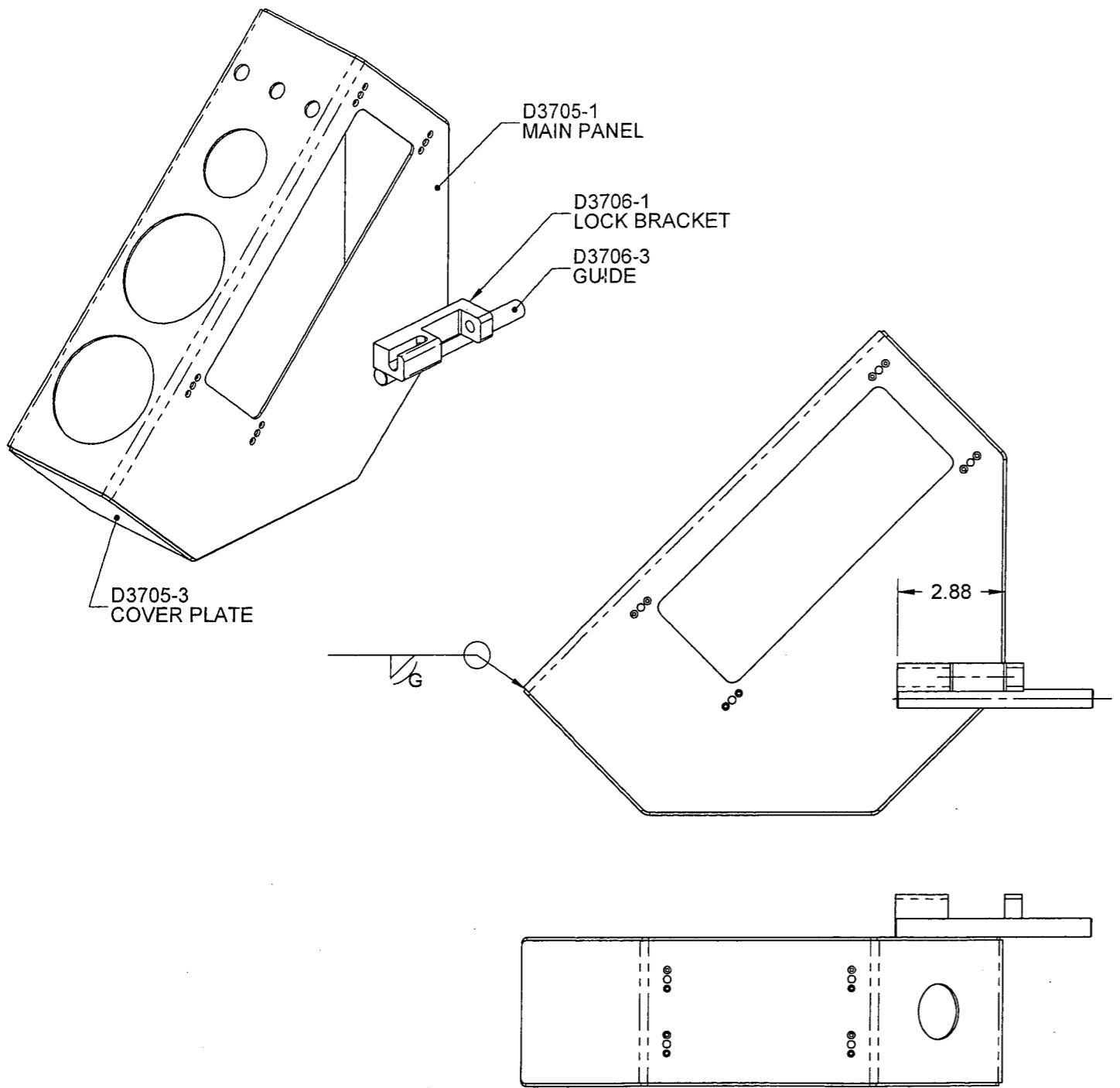
QTY	P/N	DESCRIPTION
-041		
X	D3705-041	INSTRUMENT PANEL
1	D3705-1	MAIN PANEL
1	D3705-3	COVER PLATE

PRELIMINARY ISSUE

A	NEW ISSUE	MB	08.02.06
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3705	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL	1:3
DATE	08.02.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

-043 QTY.	P/N	DESCRIPTION
X	D3705-043	INSTRUMENT PANEL WELDMENT
1	D3705-1	MAIN PANEL
1	D3705-3	COVER PLATE
1	D3706-1	LOCK BRACKET
1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3705
DE APPR.		SHEET 2 OF 5
DATE	08.05.26	TITLE
		INSTRUMENT PANEL ASS'Y
		NTS
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
[508.06.07]

8 7 6 5 4 3 2 1